

PRODUCT: MAXIM[™] Panel Bonding Adhesive
(Metal to Metal, SMC to Metal & SMC to SMC)

PART NUMBER: 100815 Universal Cartridge (250mL) 6 units/case 7 lbs/case

DESCRIPTION: Maxim[™] Panel Bonding Adhesive is a one-to-one epoxy adhesive used for bonding various surfaces. It is used for replacing door skins, roofs, quarter panels, truck bedsides, utility vehicle sides and other non-structural panels. Maxim[™] Panel Bonding Adhesive has excellent adhesion to SMC, cold rolled steel, aluminum and e-coats. Maxim[™] Panel Bonding Adhesive is backed with a full lifetime warranty by Fibre Glass-Evercoat.

FEATURES & BENEFITS: Packaged in a Universal Cartridge: applied with a standard-style, heavy duty caulking gun
1:1 mix ratio
Contains glass beads for control of bond line thickness
Corrosion resistant properties: eliminates application of epoxy or self-etch primers
Excellent working times
Superior sag resistance
Easy to brush and spread
Excellent adhesion to SMC/FRP
Cure time can be accelerated with heat

PREPARATION: Remove damaged panel. Grind surface area with 36-50 grit to remove adhesive, rust and other contaminants. Straighten damaged area. On quarters and roofs, **grind the new panel to bare steel. On e-coated door skins, scuff the panel to remove the gloss. Dry fit the panel to check for proper alignment. Clean the contact surface areas.**

APPLICATION: Equalize the cartridge to remove any air. Affix Evercoat-supplied mix tip to cartridge. Gun out a bead of adhesive until a uniform color is achieved. Apply a 1/4" – 3/8" bead of **Panel Bonding Adhesive** to the contact surfaces. Brush the adhesive to a thin coat to cover all exposed bare metal. Apply a second 1/4" – 3/8" bead of the adhesive to one contact surface only. Align the contact surfaces. Clamp or screw the contact surfaces. Remove all excess adhesive from the seam. Once parts are clamped, do not re-position after 15 minutes. Wait at least 4 hours before removing the clamps or screws. Cure time can be accelerated with heat (not to exceed 180°F/82°C). Store used cartridges with the tip down or remove tip and reinsert the original plugs.

TECHNICAL SPECIFICATIONS:

- Appearance Gray/Black
- VOC None
- Odor Low
- Tooling (Brushability) Time 25-35 minutes
- Working Time *40-50 minutes
- Clamp Time 3.5 hours
- Full Cure 24 hours @ 70° F (21°C)
- Contents and Caution MSDS available upon request
- Additional Information www.evercoat.com

* May vary due to temperature and/or application techniques

Maxim Adhesives Work Time Comparisons			
812	814	815	816
10-15 min.	30-40 min.	40-50 min.	100-120 min.

All may vary due to temperature and/or application techniques